

Work Order ID 118355

118355

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June-20-14 7:53:53 AM

Item ID: D4879-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206A/B AFT Leg Assembly, RH
 Start Date: 6/20/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/20/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference: rework to Rev. B

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4879	A								

110

0.00

110

Small Fab

Small Fab

Memo

0.00

PULL FROM KIT D206-811-011 B116555:
 1 X D4879-042 B116571
 REWORK TO REV.B

ALIGN PILOT HOLES IN D4879-1 WITH PILOT HOLES IN D4885-2 AND
 D4885-7. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
 DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
 DT9969 AS PER DWG.

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

SPR
M/6/25

1 *FF 14-06-24*

1

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130		0.00							
130									
Small Fab	Memo	0.00							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9969 A/R HYSOL BATCH: <u>17128 703</u>								

140	QC5- Inspect part completeness to step on W/O	0.00							
140									

QC									
Quality Control	145 Purchasing - send to f+l for assy part marking 146 Packaging - receive transport for transit damage 147 All st	0.00							
150	Identify as per dwg & Stock Location <u>230</u>	0.00							

150									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								

received 8/14/18
① FF 14-06-24

① 14-08-18
DAS
9
9-89

→ CD 14/08/18 P/O: 25267
→ ① 14-08-19
DAS
9
9-89
AUG 19 2014 ①

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June-20-14 7:53:53 AM

Item ID: D4879-042 Accept *N900040100* Setup Start *NS1*
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Start Date: 6/20/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 6/20/14 Req'd Qty: 1.00 *1* Customer:
Reference: rework to Rev. B

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 14-08-20

4-8-19

Picklist Print

June-20-14 7:53:53 AM

Page 1

Work Order ID: 118355

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Parent Item: D4879-042

D4879-042

Parent Item Name: 206A/B AFT Leg Assembly, RH

Start Date: 6/20/14

Required Date: 6/20/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4879-042

Manufactured No

Each 0.0000

1

D4879-042

206A/B AFT Leg Assembly, RH

116571

CMF 14-8-20

HL 20PB-5-12 : m 128973

(2x)

FF

14-06-24

HL 86-5 : m 128228

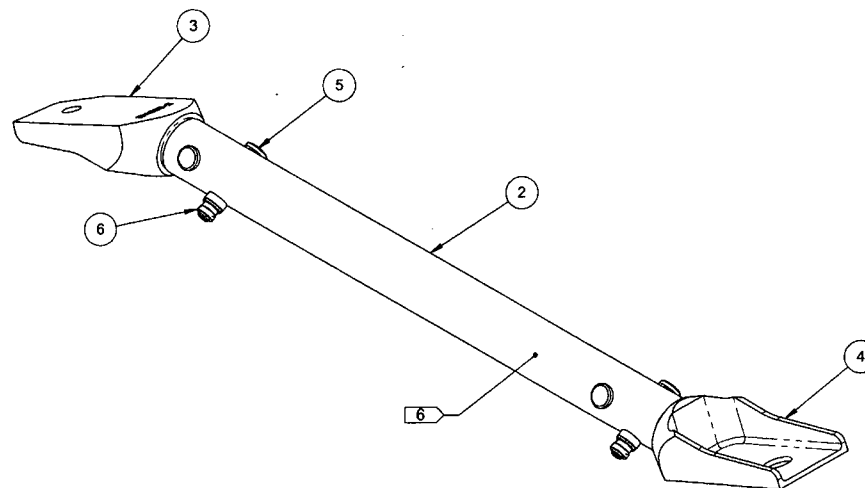
(2x)

FF

14-06-24

~~HySol EA934NA : M 128702~~

ITEM	QTY. -042	P/N	DESCRIPTION
1	X	D4879-042	AFT LEG ASSEMBLY, RH
2	1	D4879-1	STRUT
3	1	D4885-2	END FITTING
4	1	D4885-7	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4879-042 AFT LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 206-062-103-002)

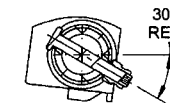
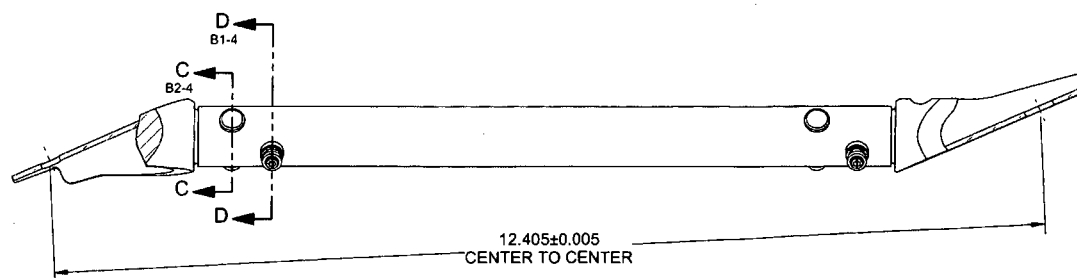
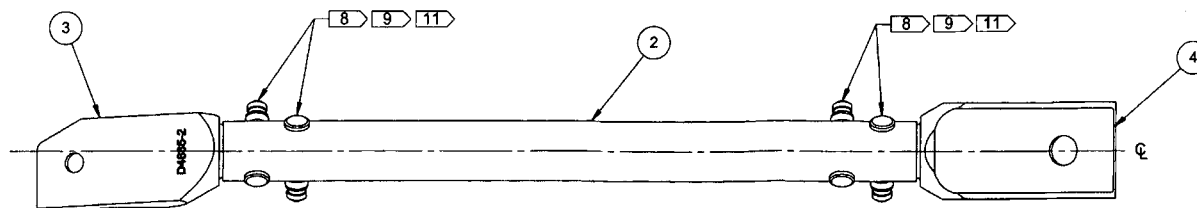
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.78 lbs
- 8) ALIGN PILOT HOLES IN D4879-1 WITH PILOT HOLES IN D4885-2 & D4885-7.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9969
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9969
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

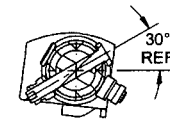
RELEASED
2014-06-16
MP

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D4879	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.04.08	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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SECTION C-C B7-4
2 PL
B



SECTION D-D B7-4
2 PL
B

D4879-042 AFT LEG ASSEMBLY, RH
AUXILIARY VIEW

RELEASED
2014-06-16

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D4879	SHEET 4 OF 5
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25267**

Purchase Order Date 7/31/2014

PO Print Date 8/1/2014

Page Number 2 of 5

Order From :
P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

VC-PL001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via: —

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Line Total: \$3.00

4	121382	D4879-041 AFT LEG ASSEMBLY	8/7/2014	1.00	\$3.00	\$3.00
			Yes 8/7/2014			

LASER MARKED

Line Total: \$3.00

5	121585	D4879-042 AFT LEG ASSEMBLY	8/7/2014	1.00	\$3.00	\$3.00
			Yes 8/7/2014			

LASER MARKED

Line Total: \$3.00

6	118355	D4879-042 AFT LEG ASSEMBLY	8/7/2014	1.00	\$3.00	\$3.00
			Yes 8/7/2014			

LASER MARKED

Note:

8/1/2014



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

Invoice

Number: 7242

Date: August 12, 2014

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
25267		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4801-041	2.00	3.00	✓	6.00
Laser Metal Marking, D4878-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4879-041	1.00	4.00	✓	4.00
Laser Metal Marking, D4879-041	1.00	4.00	✓	4.00
Laser Metal Marking, D4879-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4879-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4928-041	2.00	3.00	✓	6.00
Laser Metal Marking, D4928-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4835-041	1.00	4.00	✓	4.00
Laser Metal Marking, D4837-041 ✓	2.00 ✓	3.00	✓	6.00 ✓
Laser Metal Marking, D4801-042	2.00	3.00	✓	6.00
Sub-Total				\$52.00
13.00% on 52.00				6.76
Total				\$58.76

Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE Aug. 12, 2014

P.O NUMBER PO25267

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4801-041 LEG ASSEMBLY	2	ALL ITEMS HAVE BEEN LASER MARKED
D4878-042 LEG ASSEMBLY	1	
D4879-041 LEG ASSEMBLY	1	
D4879-041 LEG ASSEMBLY	1	
D4879-042 LEG ASSEMBLY	1	
D4879-042 LEG ASSEMBLY	1	
D4928-041 LEG ASSEMBLY	2	
D4928-042 LEG ASSEMBLY	1	
D4835-041 LEG ASSEMBLY	1	
D4937-041 LEG ASSEMBLY	2	
D4801-042 LEG ASSEMBLY	2	